			
	_		
Warle	Ondon	ID	E0420
WULK	Order	\mathbf{u}	ラブ4 ラレ

Friday, June 04, 2010 9:26:38 AM



Page 1

Item ID:

D3912-3

Accept



Setup Start

Stop



Revision ID:

Start Date:

Eyebolt Block Item Name:

Required Date: 6/10/2010

6/4/2010

Start Qty: 24.00 Req'd Qty: 24.00

Cust Item ID: Customer:

Reference:

Approvals:	Proc

Date: 16-6-04 Tooling:

Date:_

SPC (Y/N):

Date: Date:

Start Run



Stop

Sequence ID/ Work Center ID Operation Description

Set Up/ **Run Hours**

Tool ID

Tool # Plan

Accept Code Qty

Reject **Qty**

Reject Insp. Stamp Number

Draw Nbr

Revision Nbr

QC:

D3912 Α

100

Cut blanks as per folio

0.00

mf 10/06/05

24 8

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 2.50" LONG

110



HAAS 1

HAAS CNC vertical machine #1

0.00

0.00

MACHINE AS PER FOLIO FA870 AND DWG

FOLIO REV: DWG REV:

ml 10/06/06

DEBURR

Memo

Dart A	Aerospa	ace	Ltd
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W/O:			WORK ORDER O	CHANGES				
DATE	STEP	PROC	EDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date:	L

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: _____

NCR:			WORK ORDI	ER NON-CONFORMANC	E (NCR)			,
5.475		Description of NC		Corrective Action Section B		Varification		Τ
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
								·

Page 2

Item ID:

D3912-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Eyebolt Block

Start Date: 6/4/2010 Required Date: 6/10/2010 **Start Qty: 24.00**

Req'd Qty: 24.00



Cust Item ID:

Customer:

Reference:

A
Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Date:

Run

Start

Stop



QC:

Date: _____ SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ **Work Center ID**

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

0.00

Set Up/

Run Hours

a. L. 10/06/06

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00 A.A 10/06/07

160

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Dart	Aer	osp	ace	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					i i				
Part No	•	PAR #:	Fault Categ	gory:	NCR: Yes	No DC)A:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC	Description of NC Corrective Action				ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector
						;			
					-				
	.								
	1				-				İ

Work Orde	r ID 59430
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Friday, June 04, 2010 9:26:38 AM

Required Date: 6/10/2010



Page 3

Item ID:

D3912-3

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Eyebolt Block

6/4/2010

Start Qty: 24.00

Req'd Qty: 24.00



Cust Item ID: **Customer:**

Reference:

Αı	opr	ova	ls:

Process Plan:

Date: Date: **Tooling:** SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

Operation Description

QC:

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

Memo

0.00

Quality Control

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CH	ANGE	B	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Y	es N	o DQ	A :	Date:)
		esolution:								
NCR:		V	VORK ORE	ER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC	Initial		tion B	0	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		gn & late	Section	on C	Chief Eng	QC Inspector
<u> </u>								:		
										1 man man man man
									••	

Picklist Print

Friday, June 04, 2010 9:26:42 AM

Work Order ID: 59430

Parent Item:

D3912-3

Parent Item Name:

Eyebolt Block

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD



Start Date: 6/4/2010

Required Date: 6/10/2010

Page 1

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	16.2863	0.208	5.254737			

303 BAR 1" X 1"

 Location
 Loc Oty
 Loc Code

 MAT53
 16.2863

 113341
 12

 → 113719
 4.2863

2.197 2057 m/0/06/05

	-								•
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA					Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•						
		•							
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	J
				osition: Date: Date:					
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE STEP		Description of NC Corrective Action			Section B Verifi			Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
<u>.</u>									

				•					
			1		i			i e	1

DART AEROSPACE LTD	Work Order:	59430
Description: EYEBOLT BLOCK	Part Number:	D3912-3
Inspection Dwg: 03912 Rev: A		Page 1 of 1

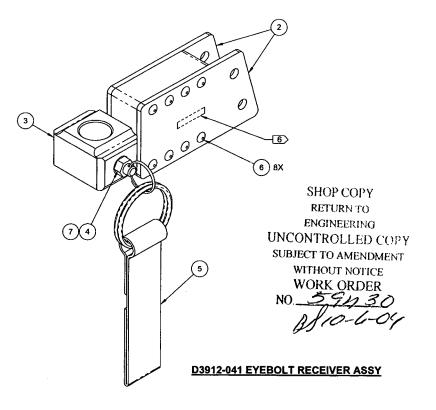
FIRST ARTICLE INSPECTION CHECKLIST

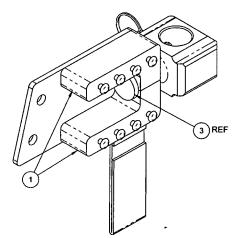
		First Artic	:le	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
, 800	+.000	797				
. 400	=,010	. 400				
1.00	±.030	.991				
.576	=:000	.576				
, 38	±.036	-380				
2.30	±.030	2.300				
. 500	1.010	. 300				
8.129	+.005	8.129				
. 50	±.030	,495				
R.13	= ±-036	R.130				
. 500	±.010	,495				
R.125	±.080	R.125				
.63	±.030	-626				
750	± :000	-737				
		1				
		1	-			
		<u> </u>				
Measured by:		Audited by:	1, 0		Drototypo Annr	N/A

Rev Date	Change	•	Revised by	Approved
Α	New Issue		KJ/JLM	

N/A

ITEM QTY		P/N	DESCRIPTION
	Х	D3912-041	EYEBOLT RECEIVER ASSY
1	2	D3912-3	EYEBOLT BLOCK
2	2	D3912-5	EYEBOLT PLATE
3	1	D3912-1	EYEBOLT
4	1	D3810-1	SPRING PLUNGER
5	1	D4028-041	SPRING PIN LANYARD ASSY
6	8	MS20615-4M20	RIVET
7	1	MS21209-C610	HELICAL (RED LOCKING)





SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

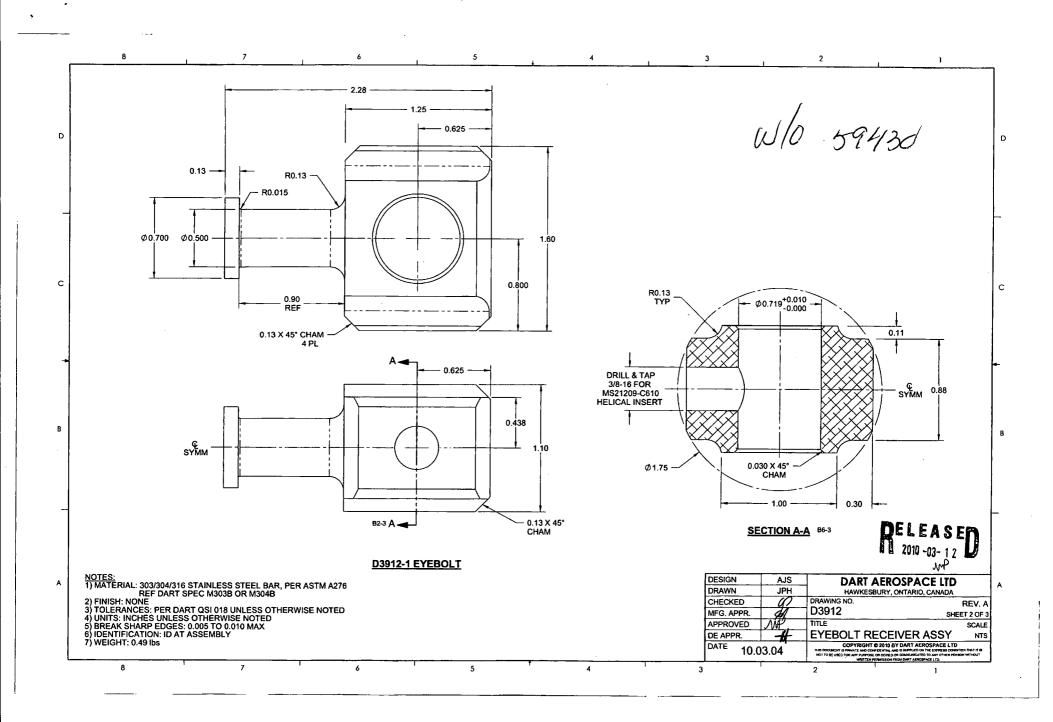
NEW ISSUE Α 10.03.04 REV. DESCRIPTION BY DATE DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA W) CHECKED DRAWING NO. REV. A D3912 MFG. APPR. SHEET 1 OF 3 TITLE APPROVED SCALE **EYEBOLT RECEIVER ASSY** DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFEDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION TO TO BE USED FOR ANY PURPOSE OR COMMANDATED TO ANY OTHER FETTH DATE 10.03.04

NOTES: 1) MATERIAL: N/A

1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER

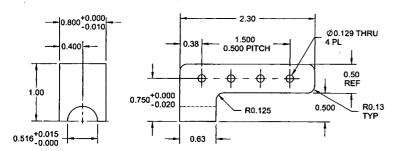
5

W/O:	·			VORK ORDI	ER CHANG	FS					•
DATE	STEP	PRO	OCEDURE C				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:									
	Res	solution:	Disposit	ion:		_ QA: N	I/C Clo	sed:		Date:	
NCR:			WORK OR	DER NON-C	ONFORMA	NCE (NCR)		** ***********************************		
DATE	STEP	Description of NC	Initial	Corrective A	Action Section Description		Sign &	Verific		Approval	Approval
		Section A	Chief Eng		Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
	-										
			·								

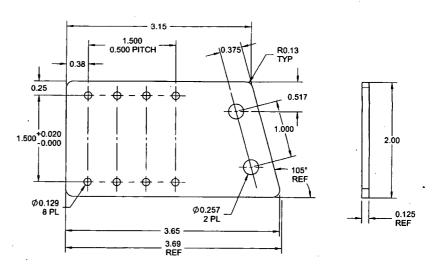


W/O:	WORK ORDER CHANGE									
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-		
Part No		PAR #:								
	R	esolution:							Date:	
NCR:		1	WORK ORD	ER NON-CONFO	RMANCE	(NCR)			
DATE STEP		Description of NC	Initial	Corrective Action	Section B	Cian 0		ation	Approval	Approval
		Section A	Chief Eng	Action Descrip Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
					, <u></u>					

wlo 59438



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

8

2) FINISH: NONE 3) TOLERANCES: PER 4) UNITS: INCHES UNLI

4) ONTO: INCIES UNLESS OTHERWISE NOTEL 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: ID AT ASSEMBLY 7) WEIGHT -3: 0.30 lbs -5: 0.24 lbs

DART SPEC M303S11GA OR M304S11GA		DESIGN	AJS	DART AEROSPACE LTD
		DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
R DART QSI 018 UNLESS OTHERWISE NOTED	,	CHECKED	9	DRAWING NO.
NLESS OTHERWISE NOTED	•		17/	1D2042

MFG. APPR. APPROVED DE APPR.

DESIGN

SHEET 3 OF 3 TITLE EYEBOLT RECEIVER ASSY

DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD 10.03.04

REV. A

SCALE

NTS

Dail Moi Obbacc Eta	Dart	Aer	ospa	ace	Ltd
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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
	R	lesolution:	_ Dispositio	n:	_ QA: N/C Cld	sed:	Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		W	ORK ORD	ER NON-CONFORM	ANCE (NCR)		
DATE STEP		Description of NC Corrective Action			ion B	Verification	tion Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
						,		